

Work Order ID 57702

Page 1

April 14, 2010 8:26:28 AM

Item ID: D212-601-042

Accept



Setup

Start



Revision ID:

Item Name: Heli-Utility-Pod RH, 205/212/214/412

Stop



Start Date: 5/28/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/04/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/14/14 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
IIN-D212-601	B	

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

0.00

110



Pick Kit

Packaging

Packaging

0.00

0.00

for BG 10-9-28
8/10/29

10/9/28 sl

120



QC4- 100% Inspect kits for completeness

QC

Quality Control

0.00

0.00

0.00

8/10/29

(4) _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 6/04/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Identify and pack for shipping as per PPPD212-601-042
Location: _____
PPP Rev: DRAFT

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Picklist Print

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Work Order ID: 57702



Parent Item: D212-601-042



Parent Item Name: Heli-Utility-Pod RH, 205/212/214/412

Start Date: 5/28/10

Required Date: 6/04/10

Comments: IPP Rev. A New Issue 08.07.16 DL verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3192-042 		Purchased	No				Each	0.0000	1.0000		B57701	
---------------	--	-----------	----	--	--	--	------	--------	--------	--	--------	--

pod assembly 		Manufactured	No				Each	4.0000	1.0000		10/09/28 sf	
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Strut Details

Warehouse
Location

Main Warehouse

ST272

Loc Qty

4

40616

Loc Code

1

D2199-5 		Manufactured	No				Each	4.0000	1.0000		10/09/28 sf	
-------------	--	--------------	----	--	--	--	------	--------	--------	--	-------------	--

Strut Details

Warehouse
Location

Main Warehouse

ST272

Loc Qty

4

40617

Loc Code

1

D2199-9 		Manufactured	No				Each	1.0000	1.0000		10/09/28 sf	
-------------	--	--------------	----	--	--	--	------	--------	--------	--	-------------	--

Strut Details

Warehouse
Location

Premier

Mezz

Loc Qty

1

22497

Loc Code

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 6/04/10

Comments: IPP Rev. A New Issue 08.07.16 DL verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-5A 		Purchased	No				Each	321.0000	3.0000		10/9/2010	5J

Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST356	321
112933	21
114108	100
114330	200

AN4-7A



Bolt

Purchased	No		Each	249.0000	2.0000	
-----------	----	--	------	----------	--------	--

3

10/9/2010

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST356	249
113226	249

AN4-10A



Bolt

Purchased	No		Each	72.0000	2.0000	
-----------	----	--	------	---------	--------	--

2

M114523 10/9/2010

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST356	72
111425	22
113422	50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 5/28/10

Required Date: 6/04/10

Comments: IPP Rev. A New Issue 08.07.16 DL verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN5-7A Purchased No Each 206.0000 1.0000



Bolt

10/9/28/0

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST337 206

113149
113226

200

6

Each 189.0000 1.0000



AN5-10A

Purchased No

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST337 189

114056
114199
114227

39

100

50

Each 0.0000 12.0000

10/9/28/0

AN960JD416



Washer

Purchased No

NAS1149D0463J.



AN960JD516



Washer

Purchased No

NAS1149D0563J.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Start Date: 5/28/10

Required Date: 6/04/10

Comments: IPP Rev. A New Issue 08.07.16 DL verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L4 Purchased No Each 1,362.000 7.0000



MS15108 10/09/28 S

WarehouseLocation

Main Warehouse

ST139 2

111827 2

Main Warehouse

ST300 1360

113422 368

114108 984

9063 8

MS21042LS

Purchased No

Each 365.0000 2.0000



MS15156 10/09/28 S

WarehouseLocation

Main Warehouse

ST300 365

113523 26

113537 139

114108 200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	Qty -041	Qty -042	PART NUMBER	DESCRIPTION
1	X		D3192-041	UTILITY POD ASSEMBLY, LH
2		X	D3192-042	UTILITY POD ASSEMBLY, RH
5	1	1	D3192-1	HINGE (MAKE FROM D2569)
9	1	1	D2195	BRACKET
10	1	1	D2196	BRACKET
11	1	1	D2197	BRACKET
12	6	6	D2198-1	BRACKET
13	1	1	D2200-1	POD LID
14	1	1	D2200-3	POD BASE
15	3	3	D2204-6	LATCH
16	2	2	D2204-9	LATCH
17	1	1	D2258-220	PLACARD
18	1	1	D2429-041	SPRING CLIP ASSEMBLY
19	1	1	D2463-1700	NEOPRENE SEAL
20	5	5	D2528-1	BACKER PLATE
21	4	4	D2528-3	BACKER PLATE
30	1	1	D3007-041	PROP ASSEMBLY
31	2	2	D3191-1	BACKER PLATE
32	3	3	D3191-3	BACKER PLATE
33	1	1	D3191-5	BACKER PLATE
40	38	38	AD64ABS	RIVET
41	30	30	AN3-11A	BOLT
42	30	30	AN3-5A	BOLT
43	6	6	AN4-11A	BOLT
44	13	13	AN4-5A	BOLT
45	1	1	AN4-6A	BOLT
46	2	2	AN526C632R7	SCREW
47	60	60	AN960JD10	WASHER
48	21	21	AN960JD416	WASHER
49	2	2	AN960JD6	WASHER
50	2	2	MS21042L06	NUT (OR MS21042-06)
51	60	60	MS21042L3	NUT (OR MS21042-3)
52	20	20	MS21042L4	NUT (OR MS21042-4)

B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 54 lbs APPROX
- 8) SEAL ALL HOLES AND EDGES OF POD LID (ITEM 13) AND BASE (ITEM 14) WITH CYANOACRYLATE GLUE.
- 9) FOR INSTALLATION OF D3192-1 HINGE:
 - (i) TRANSFER MARK AND DRILL POD LID (ITEM 13) AND BASE (ITEM 14) Ø0.191
 - (ii) INSTALL RIVET HEADS FROM OUTSIDE OF POD.
 - (iii) GRIND TRAILING EDGE OF RIVET TO 0.100 IN HEIGHT TO PERMIT HINGE TO CLOSE.
- 10) FOR HOLES DRILLED THROUGH FOAM CORE:
 - a) DRILL Ø0.313" HOLES THROUGH POD.
 - b) CLEAN OUT FOAM Ø0.250" AROUND HOLE BETWEEN INNER AND OUTER SKINS.
 - c) APPLY TAPE TO UNDERSIDE OF SKIN (TO STOP EPOXY FILLER GOING THROUGH).
 - d) FILL CAVITY BETWEEN SKINS COMPLETELY WITH "HYSOL EA934" OR SIMILAR EPOXY POTTING COMPOUND.
 - e) AFTER THE EPOXY HAS COMPLETELY CURED, DRILL Ø0.257 FINISH HOLE SIZE FOR AN4 BOLT OR Ø0.191 FINISH HOLE SIZE FOR AN3 BOLT.
- 11) RELIEVE D2200-1 POD LOCALLY IN AREA OF D2195/D2196/D2197 BRACKETS TO CLEAR BRACKETS.
- 12) INSTALL D3191-1/-3/-5 BACKER PLATE USING SIKAFLEX -241-291 ADHESIVE.

B

B

B

B

W10:5702

CY1014/14

RELEASED
(09/01/15)

B	DRAWING TRANSFERRED TO "B" SIZE AND REDRAWN WITH CURRENT STANDARDS. -1 HINGE ADDED. ADDED ITEM 33 (SEE NCR 08-110).		AJS	09.01.05
A	NEW ISSUE		DS	03.07.01
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO. REV. B		
MFG. APPR.		D3192 SHEET 1 OF 4		
APPROVED		TITLE SCALE		
DE APPR.		UTILITY POD ASSEMBLY NTS		
DATE 09.01.05		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS BOUND TO THE CONFIDENTIALITY OF THE COMPANY AND IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED. IT IS THE PROPERTY OF DART AEROSPACE LTD AND MUST NOT BE COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

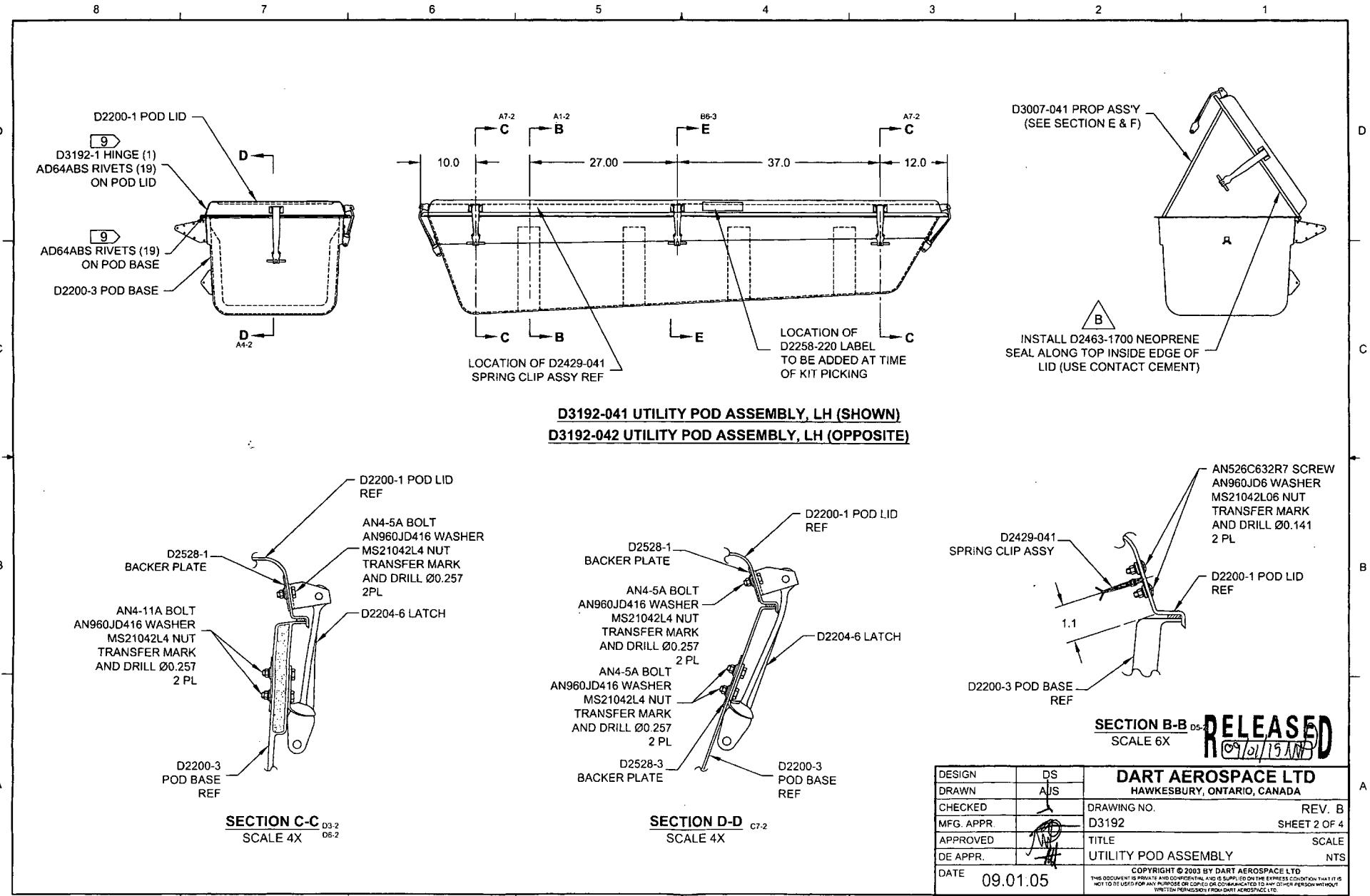
8 7 6 5 4 3 2 1

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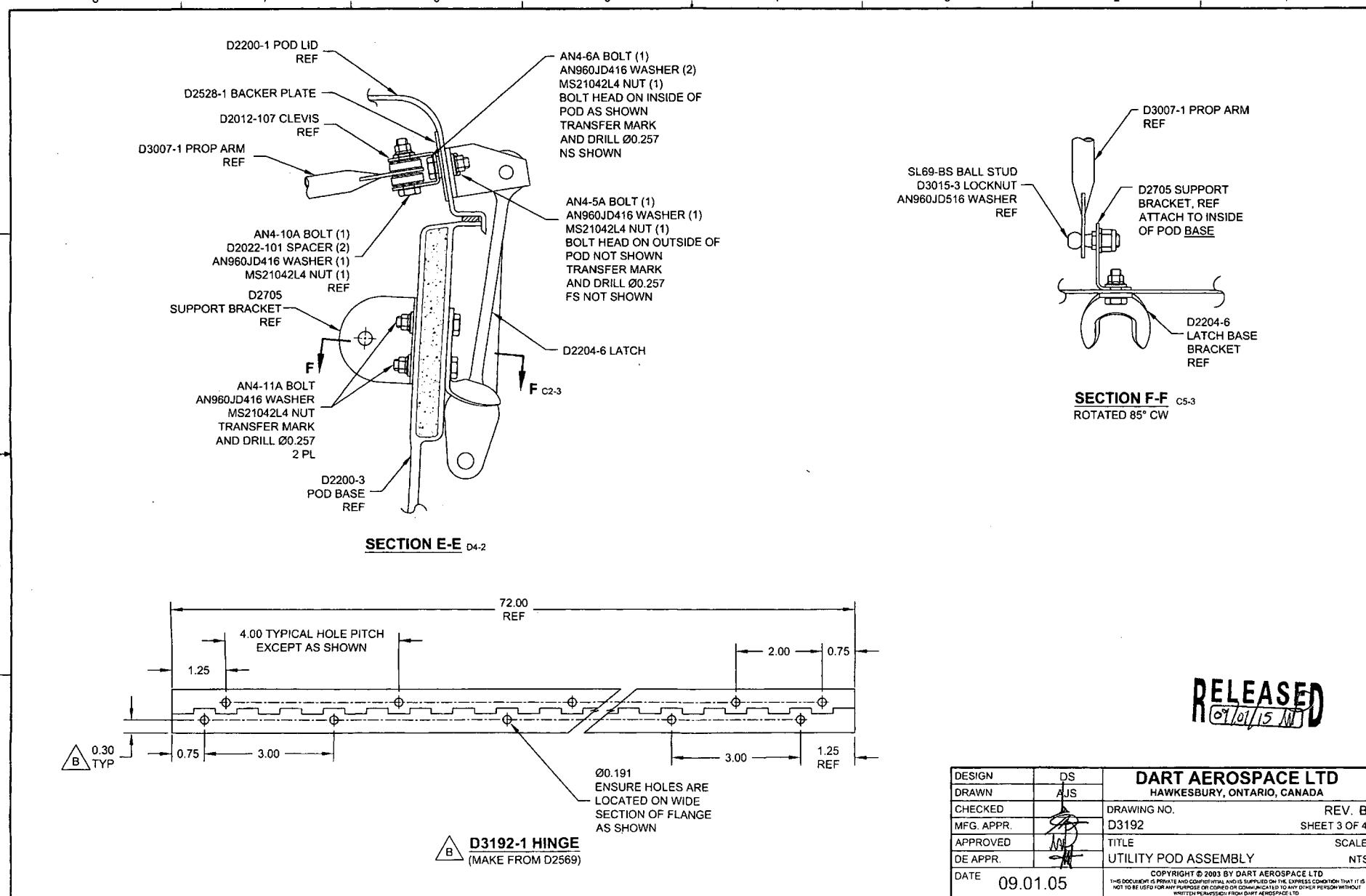


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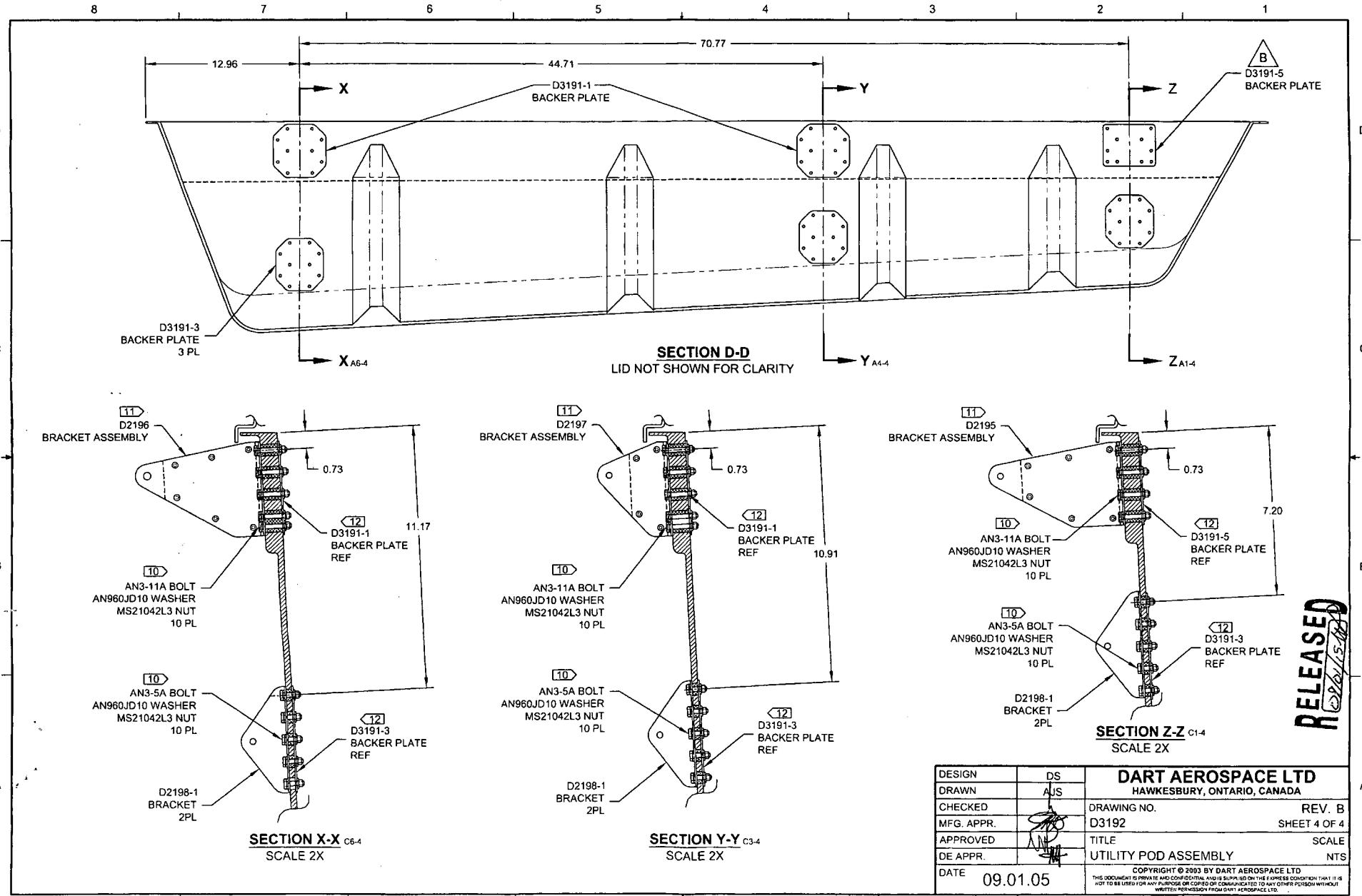


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RELEASED
06/15/2014

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

5. PARTS LIST

Qty -041	Qty -042	Part Number	Description
X		D212-601-041	HELI-UTILITY-POD LH
	X	D212-601-042	HELI-UTILITY-POD RH
1		D3192-041	POD ASSEMBLY
	1	D3192-042	POD ASSEMBLY
1	1	*D2195	BRACKET
1	1	*D2196	BRACKET
1	1	*D2197	BRACKET
6	6	*D2198-1	BRACKET
1	1	*D2200-1	LID
1	1	*D2200-2	BASE
3	3	*D2204-6	LATCH
2	2	*D2204-9	LATCH
1	1	*D2258-220	PLACARD
1	1	*D2429-041	SPRING CLIP ASSEMBLY
1	1	*D2462-1700	NEOPRENE SEAL
5	5	*D2528-1	BACKER PLATE
4	4	*D2528-3	BACKER PLATE
1	1	*D2569	HINGE
1	1	*D3007-041	PROP ASSEMBLY
3	3	*D3191-1	BACKER PLATE
3	3	*D3191-3	BACKER PLATE
38	38	*AD64ABS	RIVET
30	30	*AN3-10A	BOLT
30	30	*AN3-4A	BOLT
13	13	*AN4-5A	BOLT
1	1	*AN4-6A	BOLT
6	6	*AN4-11A	BOLT
2	2	*AN526C632R7	SCREW
2	2	*AN960JD6	WASHER
60	60	*AN960JD10	WASHER
21	21	*AN960JD416	WASHER
60	60	*MS21042L3	NUT (OR -3)
20	20	*MS21042L4	NUT (OR -4)
2	2	*MS21042L06	NUT (OR -06)
1	1	D2199-2	STRUT
1	1	D2199-7	STRUT
1	1	D2199-9 //	STRUT
3	3	AN4-5A	BOLT
2	2	AN4-7A	BOLT
2	2	AN4-10A	BOLT
1	1	AN5-7A	BOLT
1	1	AN5-10A	BOLT
12	12	AN960JD416 //	WASHER
3	3	AN960JD516	WASHER
7	7	MS21042L4	NUT (OR -4)
2	2	MS21042L5	NUT (OR -5)

*INCLUDED IN D3192-041/-042 ASSEMBLIES LISTED ABOVE

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Revision: B
 Date: 03.06.02

→ D2199-5
 OK
 M/S
 10/9/28